

**Work Order ID 50871**

July 23, 2009 9:46:09 AM

Page 1

Item ID: D2873-043

Accept

Revision ID: A

Item Name: Nut Plate Assembly

Start Date: 7/24/2009 Start Qty: 20.00

Required Date: 7/27/2009 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2873

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

S.L. 09/07/24

20

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873L Identify as D2873-3  
Dwg Rev A Folio Rev AA

S.L. 09/07/25

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

S.L. 09/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50871

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Page 2

Item ID: D2873-043

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate Assembly

Start Date: 7/24/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 7/27/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

*SB 09/07/27*

Memo

0.00

140



Small Fab

Small Fab

Small Fab

Memo

1-Deburr 1.2- C'sink as per Dwg D2873

0.00

0.00

*LP 09/07/28*

*(20)*

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*5 09/07/28*

*count  
(+20) 4*

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

BK 09-07-28 (20)

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

H 09-07-28 (20)

Quality Control

180

Small Fab

0.00



Small Fab

Memo

0.00

EP 09/07/28 (20)

Small Fab

1-Assemble as per Dwg D2873 2-Identify as D2873-043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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July 23, 2009 9:46:09 AM



Item ID: D2873-043

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Setup Start



Revision ID: A

Stop



Item Name: Nut Plate Assembly

Start Date: 7/24/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 7/27/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8 or 10 lbs

routes  
(20) 0

200

Identify as per dwg & Stock Location: X-tubes

0.00



Packaging

Memo

0.00

Packaging

ml 09 11 10 (20)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/10

MF 09-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

July 23, 2009 9:46:08 AM

Page 1

Work Order ID: 50871

Parent Item: D2873-043RevA

Parent Item Name: Nut Plate Assembly

Comments:

Start Date: 7/24/2009

Required Date: 7/27/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	24.1095	6.4905			



6061T6 BAR .375 x 1.00

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

24.10947368

105225

5.3

110829

18.8094737

MS20426AD4-6

Purchased

No

180

Each

4,212.000

120.0000



Rivet

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

-120

Main Warehouse

ST

4212

100151

27

103395

14

105144

370

110139

3774

2525

27

110829

6.4905 7/24/09 7/24

CP 509/07/28

120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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July 23, 2009 9:46:08 AM

Work Order ID: 50871

Parent Item: D2873-043RevA

Parent Item Name: Nut Plate Assembly



Comments:

Start Date: 7/24/2009

Required Date: 7/27/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L5		Purchased	No			100	Each	470.0000	60.0000			
												
Nut Plate												

*CP 09/07/28*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	-60	
111127	-31	
112243	-29	
Main Warehouse		
ST	530	
110916	79	
111127	31	
112243	420	

*60*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50871
<b>Description:</b> RADIUS BLOCK		<b>Part Number:</b> D2873-3
<b>Inspection Dwg:</b> 2873 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

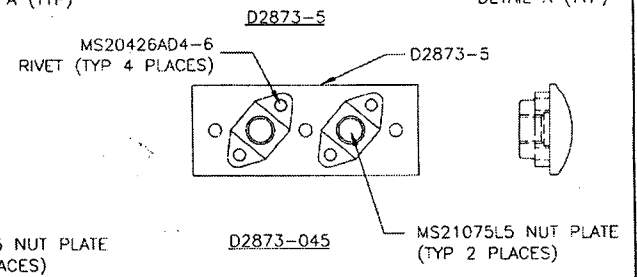
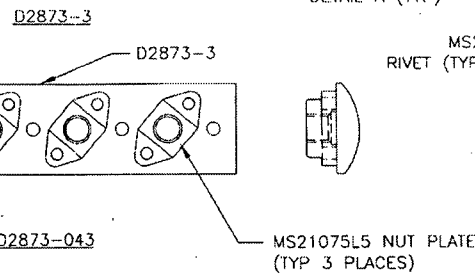
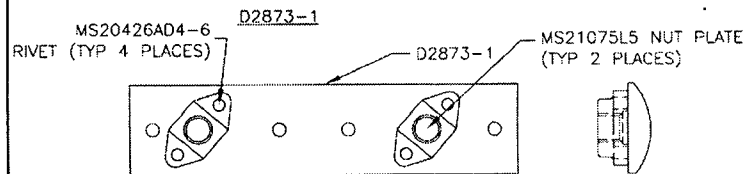
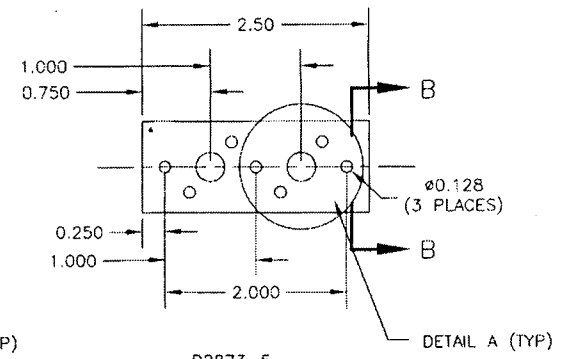
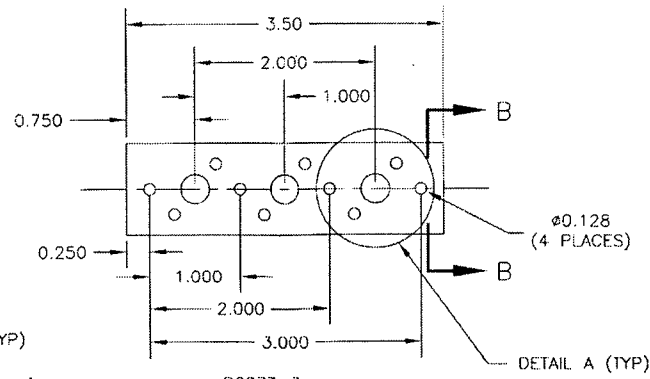
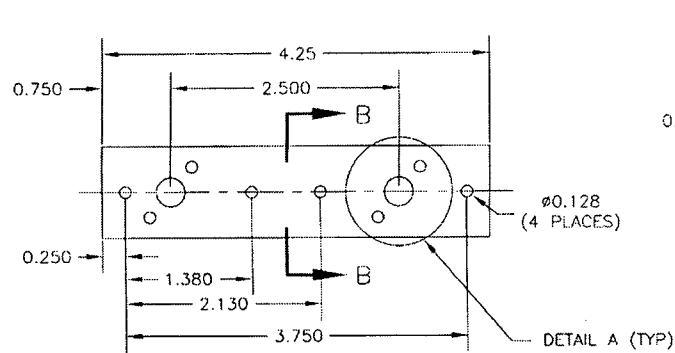
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	$\pm .03$	3.50	✓			
3.000	$\pm .010$	3.001	✓			
2.000	$\pm .010$	2.000	✓			
2.000	$\pm .010$	2.000	✓			
1.000	$\pm .010$	1.000	✓			
1.000	$\pm .010$	.998	✓			
.750	$\pm .010$	.751	✓			
.250	$\pm .010$	.250	✓			
.250	$\pm .010$	.249	✓			
1.000	$\pm .010$	1.000	✓			
.061	$\pm .010$	.060	✓			
Ø .230 x .125 deep	$\pm .005$ $\pm .010$	Ø .230 x .124 deep	✓			
Ø .128	$+ .005$ $- .001$	Ø .130	✓			
Ø .316	$+ .006$ $- .001$	Ø .320	✓			
R.80	$+ .010$ $- .001$	R.8	✓			

<b>Measured by:</b> <i>[Signature]</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/27/24	<b>Date:</b> 09/07/27	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O 50871



D2873-041

MS20426AD4-6 RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE (TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE (TYP 2 PLACES)

#### D2873-1/-3/-5 RADIUS BLOCK

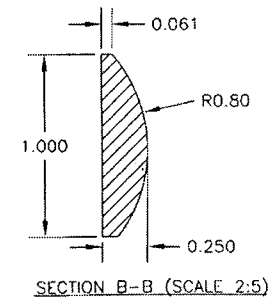
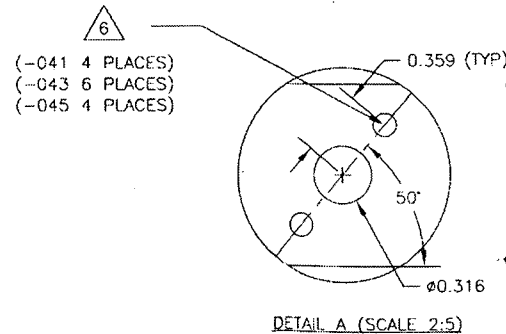
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.26	TITLE
		SCALE

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